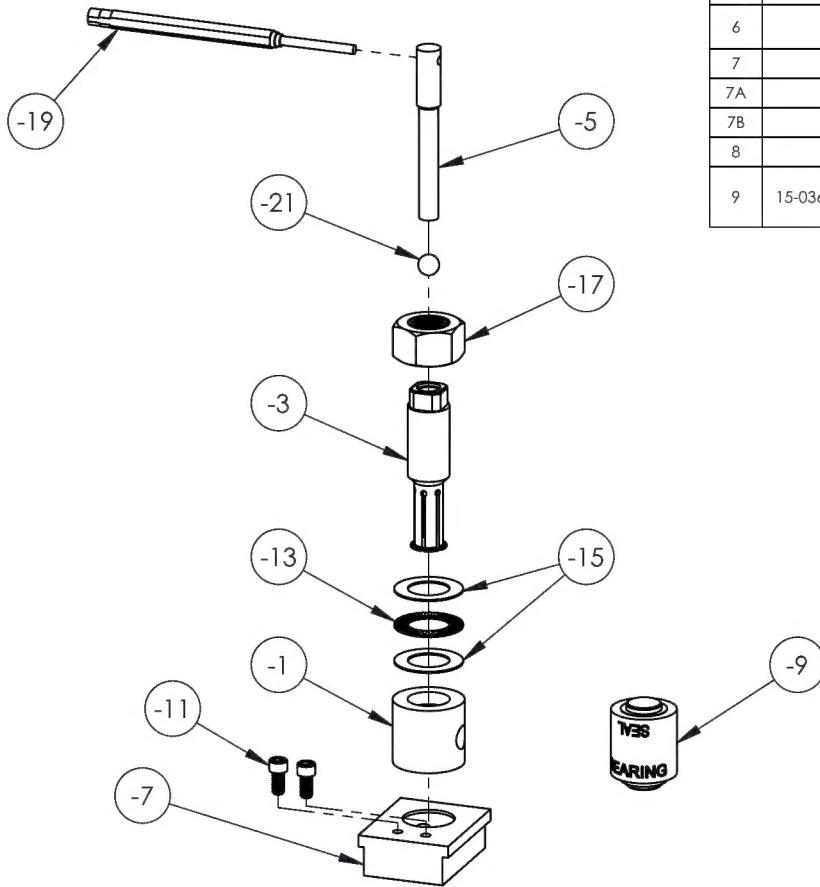
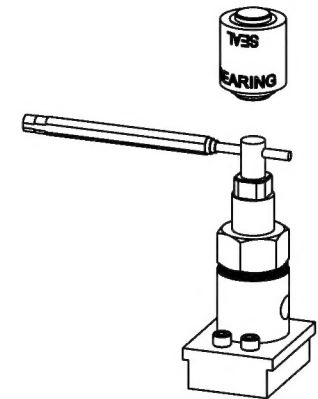


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-9 INSTALL TOOL CHANGED TO SEAT BEARING & SEAL DEEPER.	8/8/2001	-	
4		ADDED MAGNIFIED VIEW "A" FOR -9.	7/20/2006	-	
5		CORRECTED VIEW A DIA., WAS Ø.745.	3/3/2008	WP	GE
6		ADDED TABS TO PULLER AND NOT TO SECTION VIEW, ADDED ENGRAVE T/N, S/N, "MADE IN USA". ADDED PG. 1 OF 3 FOR BOM & ASSY. VIEW.	4/27/2009	RJC	
7		UPDATED TITLEBLOCK & REVISION BLOCK.	6/4/2009	RJC	
7A		ADDED INSTRUCTIONS PER R.W.	2/17/2010	RJC	GE
7B		ADDED PLEASE READ & MISUSE OF THIS TOOL NOTES TO INSTRUCTION PAGE PER E.B.	5/7/2012	RJC	EB
8		CH'D -7 DIMENSION FROM .550 TO .500 FOR 1/4-20 THRU HOLES PER G.E.	5/31/2012	RJC	GE
9	15-0361	UPDATED TO NEW DRAFTING STANDARDS. ADDED DASH No.'S FOR B/O. -3 DELETED TABS, DELETED DIMS .055, .080, .060, .100. CH'D DIM WAS .147 IS (.147). -11 ADDED B/O REF #91251A537. -17 ADDED B/O REF #95479A132. -19 ADDED B/O REF #85245165. -21 ADDED B/O REF #7/16MINIPACK.	11/18/2015	DPD	JAG



NOTE:
USED ON 206-011-814 HOUSING ASSY.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	STRESSPROOF		2
			-3	1	PULLER	H-13		3
			-5	1	RAM	4140/4142		4
			-7	1	VICE FIXTURE	ALUMINUM		5
			-9	1	INSTALL TOOL	STRESSPROOF		6
		B/O	-11	2	SOCKET HEAD CAP SCREWS	STEEL	1/4-20 X 1/2 (MCMaster-CARR #91251A537)	1
		B/O	-13	1	ROLLER BEARING	STEEL	Ø7/8 I.D. X Ø1-7/16 O.D. (NTA-1423)	1
		B/O	-15	2	BEARING WASHERS	STEEL	Ø7/8 I.D. X Ø1-7/16 X .032 (TRA-1423)	1
		B/O	-17	1	NUT	STEEL	7/8-14 (MCMaster-CARR #95479A132)	1
		B/O	-19	1	PIN PUNCH	STEEL	PROTO #J473/8X3/16 (MSC #85245165)	1
		B/O	-21	1	BALL BEARING	STEEL	GOLDSPEC Ø7/16, GRADE 25 (APPLIED #7/16MINIPACK)	1
		B/O	-23	1	PISTOL CASE	PLASTIC	(RSR SPORTS #10137)	N/S

DART AEROSPACE

TITLE
BEARING PULLER - FIXTURE

DWG NO.
RBT18531

MAT'L
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
.X ± .1

1. BREAK ALL SHARP EDGES .015 x 45°
OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SCALE 1:4

REV
9

DRAWN BY: COLE

APPROVED *D Weil*

HEAT TREAT FINISH

SPEC

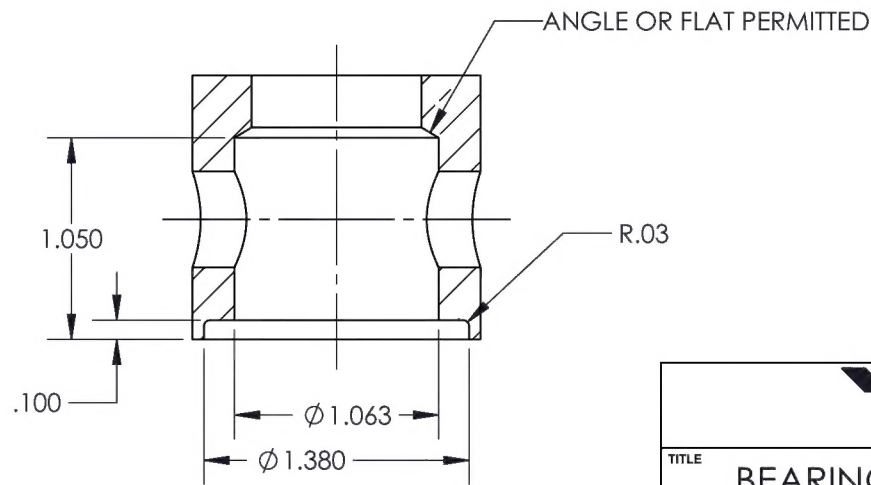
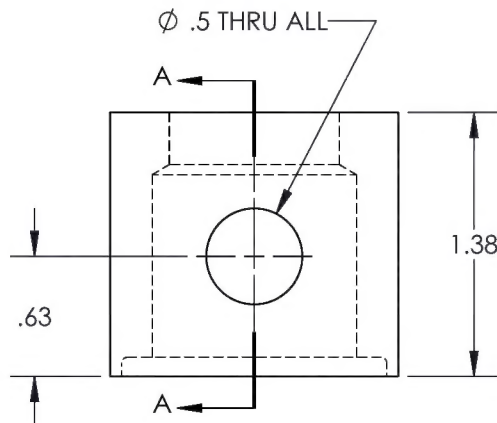
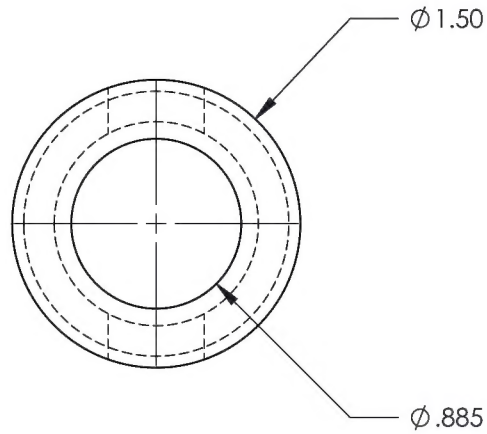
USED ON MODEL
BELL 206

DATE 8/4/2003

SHEET 1 OF 7

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



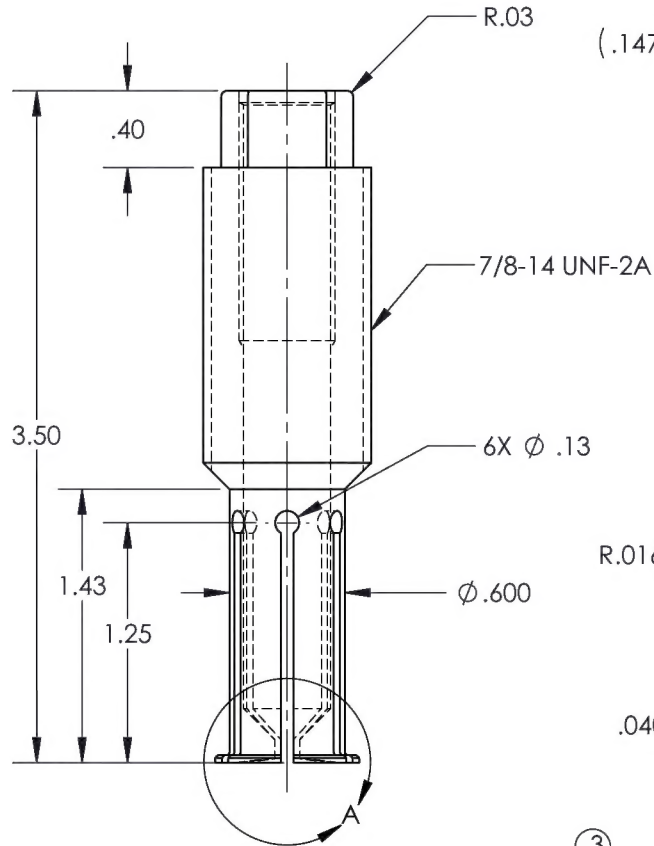
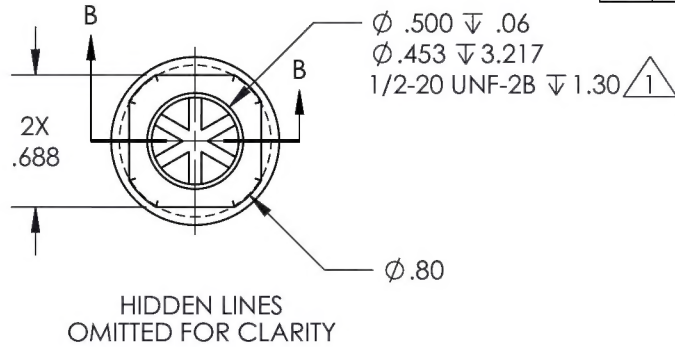
SECTION A-A

(-1)
BASE

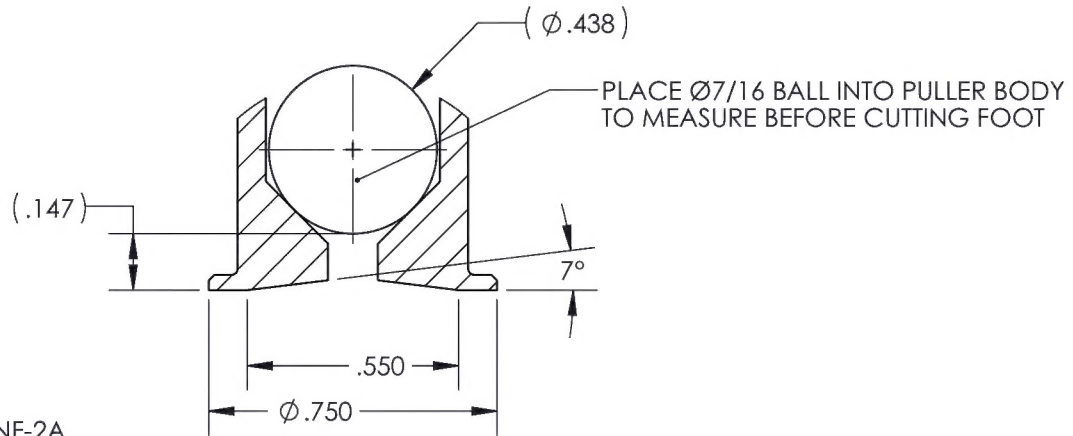
DART AEROSPACE	
TITLE BEARING PULLER - FIXTURE	
DWG NO. RBT18531-1	REV 9
MAT'L STRESSPROOF	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	BLACK OXIDE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 206
SCALE 1:1	DATE 8/4/2003
	SHEET 2 OF 7

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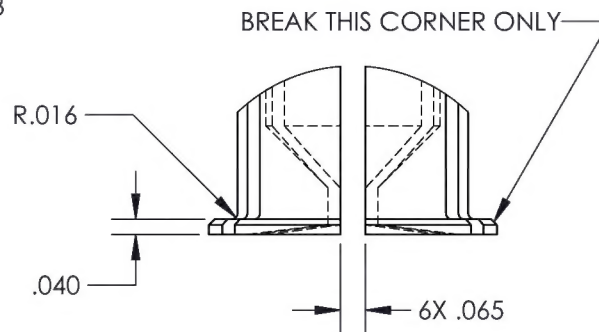
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		ADDED MAGNIFIED VIEW "A" FOR -9.	7/20/2006	-	-
6		ADDED TABS TO PULLER AND NOTE TO SECTION VIEW.	4/27/2009	RJC	-
9	15-0361	-3 DELETED TABS. DELETED DIMS .055, .080, .060, .100. CH'D DIM WAS .147 IS (.147).	11/18/2015	DPD	JAG



(-3)
PULLER



SECTION B-B
SCALE 2 : 1

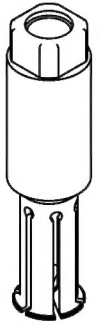


DETAIL A
SCALE 2 : 1

NOTE:

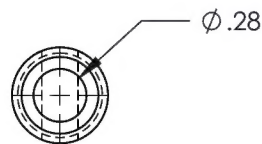
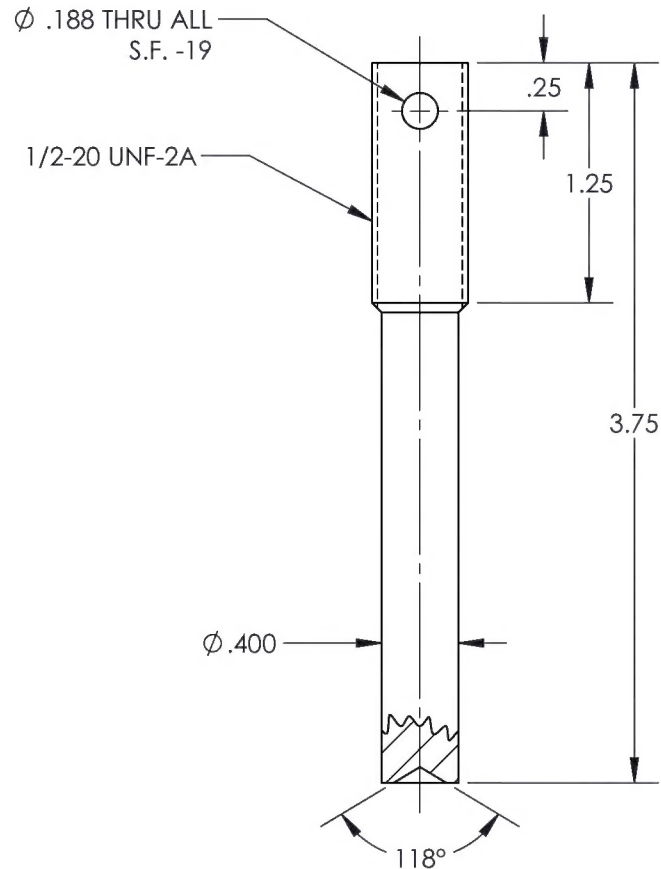
1 ENSURE THAT ID BELOW THREAD IS SMOOTH
AND FREE OF BURRS.

DART AEROSPACE	
TITLE BEARING PULLER - FIXTURE	
DWG NO. RBT18531-3	REV 9
MAT'L H-13	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>P. Weil</i>
.XXX ± .005	HEAT TREAT RC 45-52
.XX ± .01	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206
SCALE 1:1	DATE 8/4/2003
SHEET 3 OF 7	



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
9	15-0361	-5 DELETED DIM .062. ADDED DIM Ø.28.	11/18/2015	DPD	JAG

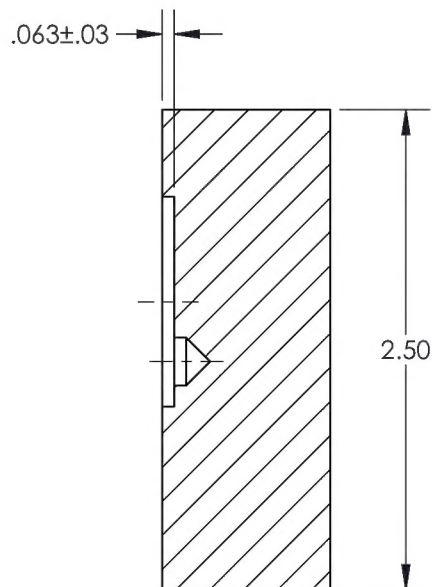
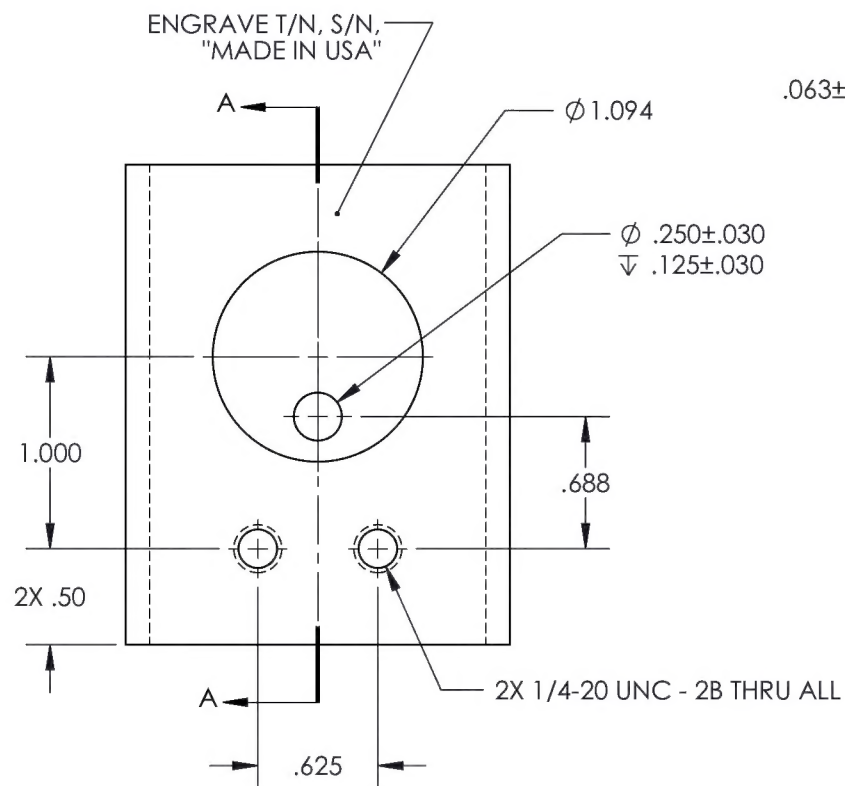


(-5)
RAM

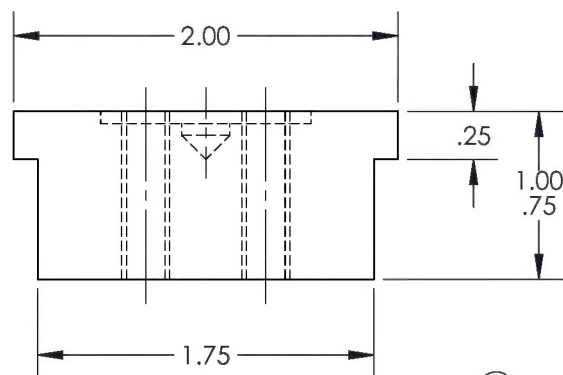
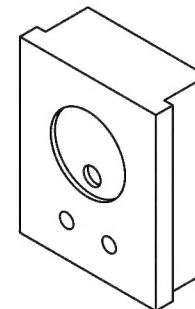


DART AEROSPACE	
TITLE BEARING PULLER - FIXTURE	
DWG NO. RBT18531-5	REV 9
MAT'L 4140/4142	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>P. Weil</i>
.XXX ± .005	HEAT TREAT RC 35-40
.XX ± .01	FINISH BLACK OXIDE
.X ± .1	ANGLES ± 5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206
SCALE 1:1	DATE 8/4/2003
SHEET 4 OF 7	


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		ADDED ENGRAVE T/N, S/N, "MADE IN USA".	4/27/2009	RJC	-
8		CH'D -7 DIMENSION FROM .550 TO .500 FOR 1/4-20 THRU HOLES PER G.E.	5/31/2012	RJC	GE



SECTION A-A

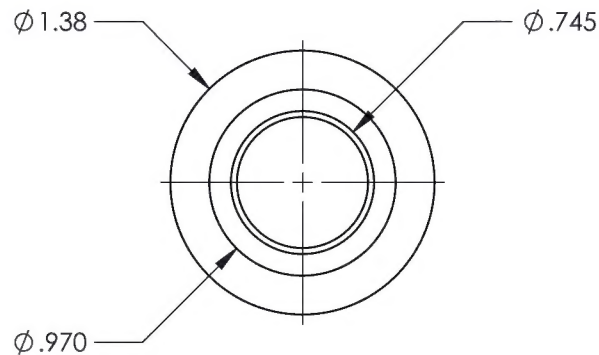
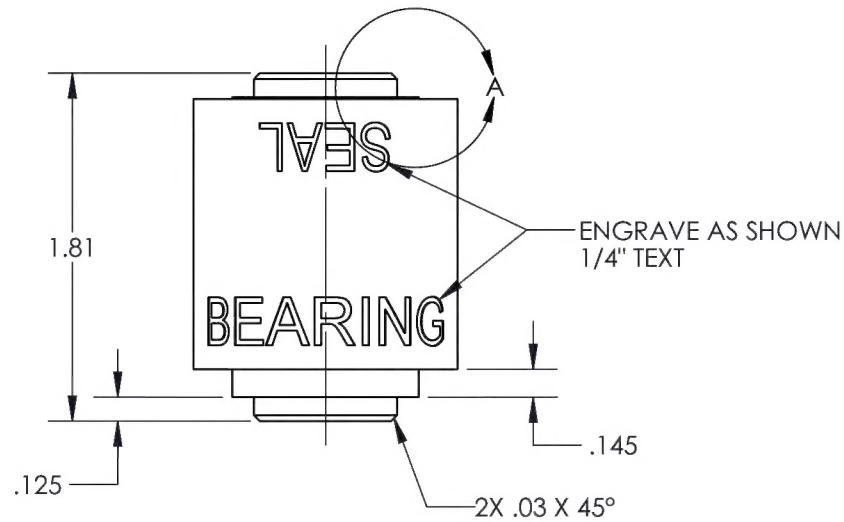


⑦
VISE FIXTURE

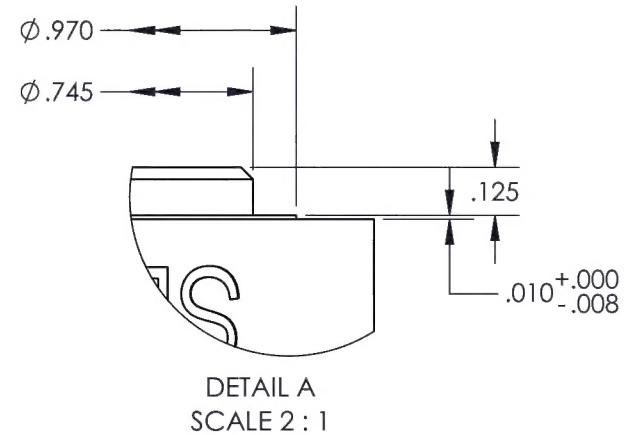
			
TITLE			
BEARING PULLER - FIXTURE			
DWG NO.			REV
RBT18531-7			9
MAT'L ALUMINUM		DRAWN BY: COLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005 FRACTIONS ± 1/8		HEAT TREAT	
.XX ± .01 ANGLES ± .5°		FINISH BLACK ANODIZE	
.X ± .1		SPEC MIL-A-8625, TYPE II, CLASS II	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		BELL 206	
SCALE	1:1	DATE	8/4/2003
		SHEET 5 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-9 INSTALL TOOL CHANGED TO SEAT BEARING & SEAL DEEPER.	8/8/2001	-	-



(-9)
INSTALL TOOL

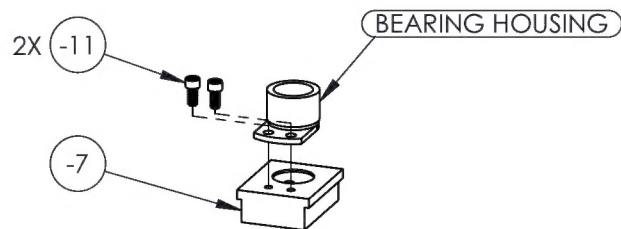


DART AEROSPACE	
TITLE BEARING PULLER - FIXTURE	
DWG NO. RBT18531-9	REV 9
MAT'L STRESSPROOF	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 206
SCALE 1:1	DATE 8/4/2003
SHEET 6 OF 7	

PLEASE READ & FOLLOW THE INSTRUCTIONS VERY CAREFULLY BEFORE USE!!!

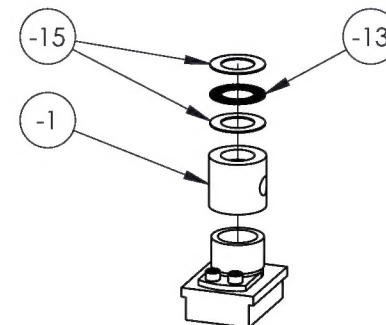
1

USE -11 CAP SCREWS TO FASTEN BEARING HOUSING ASSEMBLY TO -7 VISE FIXTURE. GRIP -7 VICE FIXTURE IN VICE.



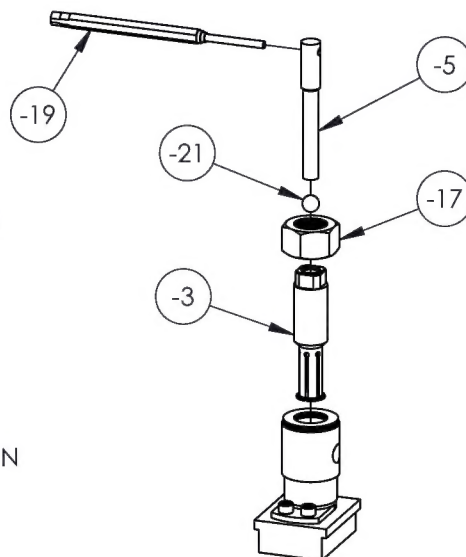
2

PLACE -1 BASE, -13 ROLLER BEARING & -15 BEARING WASHERS ON BEARING HOUSING.



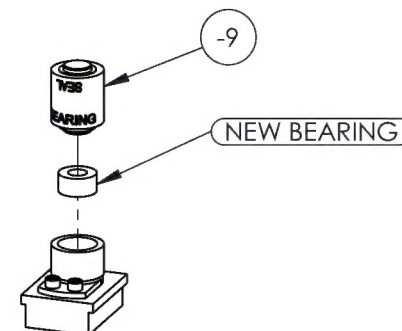
3

INSERT ASSEMBLED -3 PULLER ALL THE WAY INTO THE BEARING HOUSING. ENSURE THAT -3 PULLER IS RESTING ON THE BOTTOM OF THE BEARING HOUSING. USE -19 PIN PUNCH TO TIGHTEN -5 RAM TO EXPAND -3 PULLER TEETH, EXPAND UNTIL SNUG, GRADUALLY TIGHTEN -17 NUT TO PULL BEARING WHILE HOLDING -3 PULLER WITH AN 11/16 WRENCH TO PREVENT ROTATION. LOOSEN -17 NUT AFTER TIGHTENING 1/2 TURN AND RESEAT -3 PULLER TO THE BOTTOM OF THE BEARING HOUSING ASSEMBLY AND TIGHTEN -5 RAM IN ORDER TO OBTAIN AN ADEQUATE GRIP. REPEAT THIS PROCEDURE AS REQUIRED.



4

PRESS IN NEW BEARING USING BEARING END OF -9 INSTALL TOOL. PRESS IN SEAL USING SEAL END OF -9 INSTALL TOOL.



NOTE: BEARINGS SEATED TOO DEEPLY WILL REQUIRE REPEATING THIS PROCEDURE SEVERAL TIMES.

MISUSE OF THIS TOOL WILL VOID ANY WARRANTY

DART
AEROSPACE

190 S. Danebo Ave., Eugene, OR. 97402
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE BEARING PULLER - FIXTURE			
DWG NO. RBT18531	REV 9	CUSTOMER 1 OF 1	
SCALE 1:5	DATE 8/4/2003	SHEET 7 OF 7	